

Sp Wed July 6

Work Order ID 71400

Thursday, June 30, 2011 3:19:50 PM



~~PRELIMINARY ISSUE~~

Page 1

Item ID: D4422-3

Accept



Setup Start



Revision ID: ~~PRELIM~~

Item Name: Shim

Stop



Start Date: 6/30/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/8/2011 Req'd Qty: 1.00



Customer:

Reference:



Approvals:

Process Plan:

[Signature]

Date: 11-06-30

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4422

PA1

A

1107.06

100

0.00



Small Fab

Memo

0.00

Small Fab

Shear as per dwg D4422

[Signature] 11/07/04 ①

110

QC6- Inspect dimensions to drawing

0.00 - inspector to PA1



QC

Memo

0.00

Quality Control

[Signature] Day only
8/10/04 (tc)

120

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

[Signature] 11/17/21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Page 2

Accept

[illegible]**Setup Start**

Stop

**Cust Item ID:****Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

Plan Code

**Accept
Qty**

Reject
Qty

Reject Numbers

**Insp.
Stamp**

130

QC21- Final Inspection - Work Order Release

0.00

Abstract

QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 11-27-74 AUTH 11

RELEASED 1 DATE 11.07.08

OK TO PACKAGE W/PSI 4562-01
B/N 71937.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 30, 2011 3:19:56 PM

Page 1

Work Order ID: 71400

Parent Item: D4422-3

Parent Item Name: Shim



Start Date: 6/30/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP revA 11.06.30 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.063

Purchased

No

sf

212.9700

0.024432



6061-T6 .063 Sheet

Location

Loc Qty

Loc Code

MAT021

212.97

116308

28.5

117285

184.47

54/07/04

0.024432

Dart Aerospace Ltd

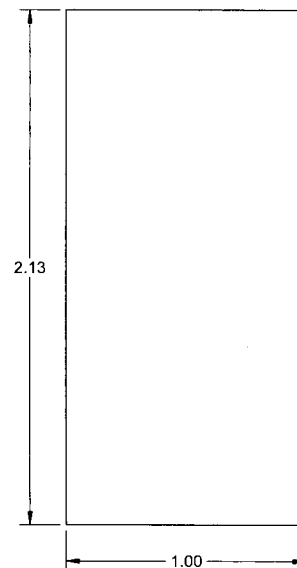
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

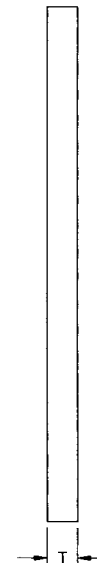
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4422-X SHIM



P/N	"T" THICKNESS
D4422-1	0.125
D4422-3	0.063

W/O 71450

PRELIMINARY ISSUE

11.06.22

NOTES:

1) MATERIAL:

D4422-1: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK, PER QQ-A-250/11
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.125
OR
6061-T6/T651/T6510/T6511/T62, 0.125 X 1.000, PER QQ-A-225/8
OR AMS-QQ-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

D4422-3: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/11
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063

OR
6061-T6/T651/T6510/T6511/T62, 0.063 X 1.000, PER QQ-A-225/8
OR AMS-QQ-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4422-X" AND B/N PER QSI 044 6.1

7) WEIGHT: D4422-1 = 0.01 lbs; D4422-3 = 0.01 lbs

PA1	NEW ISSUE		MB	11.06.22
REV.	DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD		
DRAWN		HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.		REV. PA1
MFG. APPR.		D4422		SHEET 1 OF 1
APPROVED		TITLE		SCALE
DE APPR.		SHIM		NTS
DATE	11.06.22	COPYRIGHT © 2011 BY DART AEROSPACE LTD		
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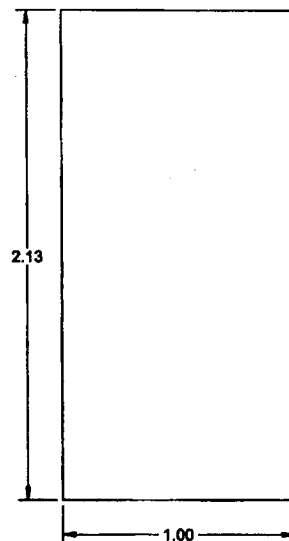
DART AEROSPACE LTD		Work Order:	B71400
Description: Shim		Part Number:	D44223
Inspection Dwg: D4422	Rev: PA1		Page 1 of 1

☒ **First Article** ☐ **Prototype**

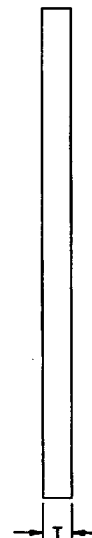
[illegible]

Measured by:	ED	Audited by:	8	Prototype Approval:	N/A
Date:	11/07/04	Date:	11/07/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D4422-X SHIM



P/N	THICKNESS
D4422-1	0.125
D4422-3	0.063

71400

NOTES:

1) MATERIAL:

D4422-1: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK, PER QQ-A-250/11
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M8061T6S.125

OR

6061-T6/T651/T6510/T6511/T62, 0.125 X 1.000, PER QQ-A-225/8
OR AMS-QQ-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M8061T6S

D4422-3: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/11
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M8061T6S.063

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

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6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4422-X" AND B/N PER QSI 044 6.1

7) WEIGHT: D4422-1 = 0.01 lbs; D4422-3 = 0.01 lbs

RELEASED
2011-07-06

A	NEW ISSUE	MB	11.06.22
REV.		DESCRIPTION	BY DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
DRAWN			
CHECKED		DRAWING NO. D4422	SHEET 1 OF 1
MFG. APPR.		TITLE SHIM	SCALE
APPROVED			NTS
DE APPR.			
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